

Date: Wednesday, 12/12/2007 11:36:52 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SPRING CLIP ASSEMBLY
Job Number	36272		
Estimate Number	10645		
P.O. Number	N/A	Part Number	D2429041
This Issue	12/12/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2429 REV C1
First Issue	12/12/2007	Type	SMALL /MED FAB
Previous Run	29025	Project Number	N/A
Written By		Drawing Revision	C1
Checked & Approved By		Material	N/A
Comment	Est. D 02.03.06 Added note at step 7 NG Est Rev:E Now on Waterjet 06-06-13 JLM	Due Date	12/19/2007
Qty:	20	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet  4047
		Comment: Qty.: 0.0071 sf(s)/Unit Total : 0.1428 sf(s) 304/316 .040 Sheet (M304S040) Batch: 105871 1B 07-12-12
2.0	WATER JET	FLOW WATER JET  
		Comment: FLOW WATER JET 1-Cut as per Dwg D2429 *****Make 2 parts per -041 assembly***** Dwg Rev: C1 Prog Rev: C1 1B 07-12-12  
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  1B 07-12-12  
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK  
		Comment: SECOND CHECK  
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2-Bend D2429-1 as per Dwg D2429  
		SB 07 12 20 57

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/12/2007 11:36:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 36272

Part Number: D2429041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



5/12/20 157 counts

Comment: INSPECT WORK TO CURRENT STEP

7.0 MS20470AD45

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part number	Description	Batch
1	MS20470AD4-5	Rivet	M104156

FF 07-12-20

28

8.0 AN960JD6L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part number	Description	Batch
2	AN960JD6L	Washer	M5519

FF 07-12-20

28

NOTE: 2 D2429-1 required for 1 assy.

28

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

FF 07/12-21

10.0 QC5

INSPECT WORK TO CURRENT STEP



one D2429 left out

5/12



Comment: INSPECT WORK TO CURRENT STEP

5/12/24 128

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 33

7/12/31 500



12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

5/12/03

28

Job Completion



min 2006/1/2 W

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

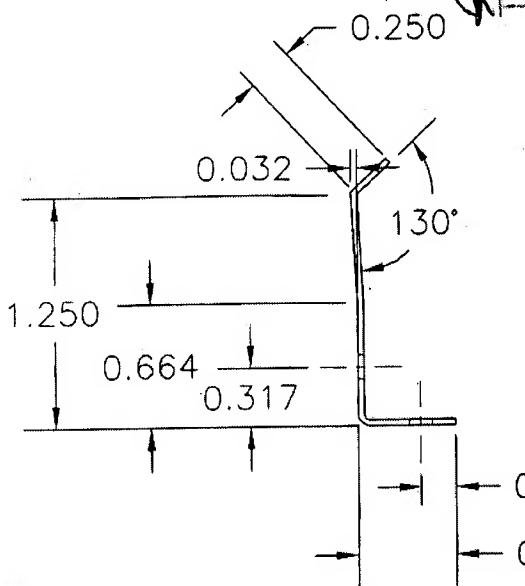
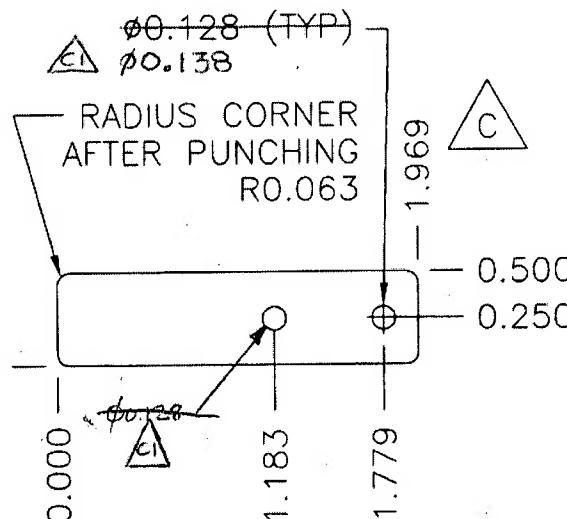
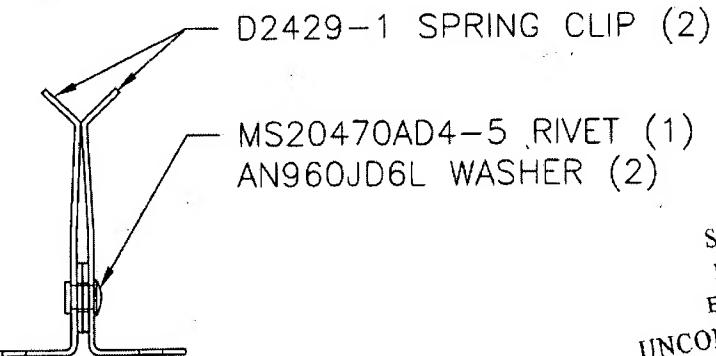
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**COPY ISSUED  
D

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26		TITLE SPRING CLIP	SCALE 1:1

**RELEASED**  
*00.06.27 ff*D2429-1 SPRING CLIPD2429-1 FLAT PATTERND2429-041 SPRING CLIP ASSEMBLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *36272*

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSION ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	36272
Description: SPRING CLIP	Part Number:	D2429
Inspection Dwg: 2429 Rev: C1	Page 1 of 1	

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article      Prototype

Measured by:	HB	Audited by:	J	Prototype Approval:	N
Date:	07-12-12	Date:	07/12/12	Date:	07/12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	